

Split

AMOD

Work Order ID 150824-2

150824

Thursday, September 08, 2016 8:33:05 AM

Page 1

DG

Item ID: D412-630-033DG

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016 Start Qty: ~~400~~

4

Cust Item ID:

Required Date: 10/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

DAS
21
9-89

Approvals: Process Plan: *SEP 08 2016*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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DAS
6
9-89

IIN D412-630	Rev O
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100

Document Control

0.00

OCT 07 2016

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-033 CHG005

DAS
28
9-89

OCT 20 2016

110

Small Fab

0.00

110

Small Fab

Small Fab

Memo

0.21

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: *123777*

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: *133690*

IX
ER

16/10/20

DAS
36
9-89

Work Order ID 150824***150824***

Page 2

Thursday, September 08, 2016 8:33:05 AM

Item ID: D412-630-033DG**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green**Start Date:** 9/30/2016 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 10/31/2016 **Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				1			DAS 38 9-89 OCT 20 2016
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				4	OCT 11 2016	DAS 6 9-89	DAS 27 9-89
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.02				1x		DAS 28 9-89	OCT 20 2016

Work Order ID 150824***150824***

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Thursday, September 08, 2016 8:33:05 AM

Item ID: D412-630-033DG

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00				1x	DAS 27 9-89	DAS 28 9-89	OCT 20 2016
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: _____								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		OCT 20 2016
160									
QC	Memo	0.07							
Quality Control									
							DAS 21 9-89		OCT 20 2016

Thursday, September 08, 2016 8:33:08 AM

Required Qty: 4.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
over005	21	
M133920	7	
M133921	7	
<u>M134131</u>	7	
ST332	18	
M132674	4	
M133091	7	
M133336	7	

Picklist Print

Thursday, September 08, 2016 8:33:08 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D2012-107

Manufactured No

110 Each 59.0000 1 4

D2012-107

Clevis

**

OCT 11 2016

DAS

6
9-89

Location

Loc Qty

Loc Code

WA004

59

145274

8

149315

51

Manufactured No

110 Each 8.0000 1 4

D2803-041

D2803-041

Bracket Assembly

**

OCT 11 2016

DAS

6
9-89

Location

Loc Qty

Loc Code

ST472

8

148426

8

Manufactured No

110 Each 1.0000 1 4

D2804-041

D2804-041

Bracket Assembly

**

OCT 11 2016

DAS

6
9-89

Location

Loc Qty

Loc Code

ST474

1

148422

1

Manufactured No

110 Each 37.0000 2 8

D2807-041

D2807-041

Prop Assembly

**

OCT 11 2016

DAS

6
9-89

Location

Loc Qty

Loc Code

FG

2

89606

2

ST011

35

142559

1

148998

4

149206

30

Picklist Print

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Thursday, September 08, 2016 8:33:08 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D2813

Manufactured No

110

Each

122.0000

2

8

NOV 11 2016

DAS

6

9-89

D2813

Washer

Location

Loc Qty

Loc Code

ST011

122

146527

18

149366

104

110

Each

264.0000

4

16

NOV 11 2016

DAS

6

9-89

D3395-1

Manufactured No

D3395-1

Bushing

Location

Loc Qty

Loc Code

ST034

264

142347

62

149467

202

110

Each

0.0000

1

4

NOV 11 2016

D3562-041

Manufactured No

D3562-041

Step Weldment

8149387

(42)

16/10/19

DAS

36

9-89

Picklist Print

Thursday, September 08, 2016 8:33:08 AM

Work Order ID: 150824

Parent Item: D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

150824

D412-630-033DG

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS21043-3 Purchased No 110 Each 1,202.000 4 16

MS21043-3

Nut

**

OCT 11 2016

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP001	11	
m130673	11	
GA	235	
m133990	235	
ST302	807	
m135058	7	
m135442	400	
m135544	400	
ST304	69	
m131340	69	

MS24665-302

Purchased No

110 Each 29.0000 2 8

MS24665-302

Cotter Pin

**

135672

OCT 11 2016

DAS
6
9-89

Location	Loc Qty	Loc Code
GA	15	
120521	15	
ST288	14	
m134738	14	

MS24693-C280

Purchased No

110 Each 11.0000 2 8

MS24693-C280

SCREW

**

135672

OCT 11 2016

DAS
6
9-89

Location	Loc Qty	Loc Code
ST287	11	
m131624	11	

Picklist Print

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Thursday, September 08, 2016 8:33:08 AM

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS24693-C285

Purchased No

110 Each

28.0000

1 4

DAS

MS24693-C285

Screw

**

OCT 11 2016 6 9-89

Location

Loc Qty

Loc Code

ST287

28

m134558

28

AN44C7A

Purchased No

130 Each

11.0000

1 4

DAS

AN44C7A

Eyebolt

**

OCT 11 2016 6 9-89 DAS 27 9-89

Location

Loc Qty

Loc Code

ST339

11

m134502

2

m135127

9

AN4C10A

Purchased No

130 Each

17.0000

1 4

DAS

AN4C10A

BOLT

**

OCT 11 2016 6 9-89 DAS 27 9-89

Location

Loc Qty

Loc Code

ST345

17

M134497

7

M135390

10

DAS
28
9-89

Picklist Print

Thursday, September 08, 2016 8:33:08 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

130

Each

96.0000

2 8

DAS

DAS

AN4C15A

Bolt

**

6

27

9-89

9-89

OCT 11 2016

Location

Loc Qty

Loc Code

FG

10

120360

10

OVER002

50

M132763

20

M133485

30

ST343

36

M130716

22

M132189

8

M132823

6

AN4C6A

Purchased

No

130

Each

590.0000

1 4

DAS

DAS

AN4C6A

Bolt

**

6

27

9-89

9-89

OCT 11 2016

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

450

m135297

50

m135470

400

over003

126

m135442

126

Picklist Print

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Thursday, September 08, 2016 8:33:08 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased No

130 Each

121.0000 2 8

**

OCT 11 2016

DAS

AN5C15A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

110

M135442

110

ST337

11

M135058

11

Manufactured No

130 Each

119.0000 2 8

**

OCT 11 2016

DAS

DAS

D2806-1

D2806-1

Bushing

DAS
28
9-89

Location

Loc Qty

Loc Code

ST011

18

142466

2

148274

16

ST012a

101

149371

101

Manufactured No

130 Each

117.0000 2 8

**

OCT 11 2016

DAS

DAS

D2806-3

D2806-3

Bushing

DAS
28
9-89

Location

Loc Qty

Loc Code

ST011

16

148330

16

ST012a

101

149456

101

Thursday, September 08, 2016 8:33:09 AM

Shop Packet Print

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Picklist Print

Page 8

Thursday, September 08, 2016 8:33:09 AM

WorkOrder ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D2810-5

Manufactured No

130 Each

6.0000

1 4

**

149358x1

OCT 20 2016

DAS
6
9-89

DAS
27
9-89

D2810-5

Strut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST377

6

134899

1

142838

5

Manufactured No

130 Each

108.0000

2 8

**

DAS
6
9-89

DAS
27
9-89

D3396-1

D3396-1

Spacer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST034

6

142351

6

ST038A

102

149446

102

Manufactured No

130 Each

354.0000

7 28

**

DAS
6
9-89

DAS
27
9-89

D3672-17

D3672-17

Phenolic Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST050

354

148074

354

Manufactured No

130 Each

416.0000

4 16

**

DAS
6
9-89

DAS
27
9-89

D3672-19

D3672-19

Phenolic Washer

small Feb

Location

Loc Qty

Loc Code

ST050

416

148075

416

OCT 11 2016

DAS
6
9-89

Thursday, September 08, 2016 8:33:09 AM

Shop Packet Print

Page 8

Picklist Print

Thursday, September 08, 2016 8:33:09 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D3672-5

Manufactured No

130 Each

622.0000

7

28

**

D3672-5

Washer, Phenolic

pkg

DAS
28
9-89

OCT 11 2016

DAS

27

6

9-89

9-89

Location

Loc Qty

Loc Code

FG

8

44679

8

ST049

234

35521

234

ST051A

380

50354

380

130 Each

883.0000

4

16

**

D3672-7

Manufactured No

D3672-7

Washer, Phenolic

5m2ll 606

OCT 11 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

343

147220

343

ST057A

500

149431

500

Picklist Print

Thursday, September 08, 2016 8:33:09 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

130

Each

735.0000

4

16

MS21043-4

Nut

**

DAS

6

9-89

OCT 11 2016

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

300

m135530

300

ST302

378

m135390

78

m135407

300

Purchased

No

130

Each

136.0000

3

12

MS21043-5

MS21043-5

Nut

**

DAS

6

9-89

OCT 11 2016

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

72

116548

72

ST302

44

m135157

2

m135470

42

Picklist Print

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Thursday, September 08, 2016 8:33:09 AM

Work Order ID: 150824

150824

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 4.00

Required Qty: 4.00

D3672-15

Manufactured No

160 Each

731.0000 5 20

DAS
6

~~9-89~~

OCT 11 2016

D3672-15

Phenolic Washer

small feb

Location

Loc Qty

Loc Code

ST050

231

148073

231

ST051A

500

149430

500

20

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)